

Work Order ID 83742

April-24-12 1:27:53 PM

ASAP

83742

Page 1

Item ID: D3562-042

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Step Assembly, RH

Start Date: 24/04/2012 Start Qty: 4.00

4

Cust Item ID:

Required Date: 08/05/2012 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals:

Process Plan: *ML5*

Date: *12/04/24*

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|

Draw Nbr

Revision Nbr

D3562

Rev E

100

0.00

100

Large Fab

Large Fab

Memo

0.00

Large Fab

1-Cut D2622 extrusion as per Dwg D3562

2-Deburr and bevel ends for welding

3-Drill hole for arms

DD 12.05.02

110

QC6- Inspect dimensions to drawing

0.00

110

QC

Memo

0.00

Quality Control

120

Chemical Conversion Coat per QSI005 4.1

0.00

120

HandFinish

Memo

0.00

Hand Finishing

4 *φ* *Ac*
12.05.02

4x *φ* *Pl*
12.05.02

(4) *ALG* *12-5-2*

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

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Stop ***NR2***

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|---|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
| 130 | QC3- Inspect Part Finish | 0.00 | | | | | | | |
| *130* | | | | | | | | | |
| QC | Memo | 0.00 | | | | 4 | 0 | | hl 12.05.07 |
| Quality Control | | | | | | | | | |
| 140 | | 0.00 | | | | | | | |
| *140* | Small Fab | | | | | 4 | 0 | | Ac 12.05.08 |
| Small Fab | Memo | 0.00 | | | | | | | |
| Small Fab | <p>1- Drill Rivet holes as per dwg D3562. Touch up alodine</p> <p>2- Rivet legs using Magnabond as per dwg D3562.</p> <p>*****Ensure to wipe off any excess magnabond *****</p> <p>A/R Magnabond 6398 Batch: <u>M120666</u></p> | | | | | | | | |
| 150 | QC5- Inspect part completeness to step on W/O | 0.00 | | | | | | | |
| *150* | | | | | | | | | |
| QC | Memo | 0.00 | | | | 24 | | | 87/10/08 |
| Quality Control | | | | | | 24 | | | |

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NOTE: Date & initial all entries

83742

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N900040100

Setup Start *NS1*

Stop *NS2*

Start Date: 24/04/2012 **Start Qty:** 4.00

4

Cust Item ID:

Required Date: 08/05/2012 **Req'd Qty:** 4.00

4

Customer:

Reference:

Run Start *NR1*

Approvals: **Process Plan:** **Date:** **Tooling:** **Date:**

Stop *NR2*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

[illegible]

| W/O: | | WORK ORDER CHANGES | | | | | |
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Item ID: D3562-042

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N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Step Assembly, RH

Start Date: 24/04/2012 Start Qty: 4.00

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Cust Item ID:

Required Date: 08/05/2012 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***
Stop ***NR2***

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|---|---|----------------------|---------|--------|--------------|---------------|---------------|------------------|-----------------|
| 190 *190* HandFinish Hand Finishing | Chemical Conversion Coat per QSI005 4.1 Memo | 0.00 0.00 | | | | 4X | ✓ | | M-L 12/05/10 |
| 200 *200* Powdercoat Powder Coating | White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum Memo START TIME: 2:15 OVEN TEMPERATURE: 320 °F FINISH TIME: 2:45 | 0.00 0.00 | | | | 4X | ✓ | | M-L 12/05/10 |
| 210 *210* HandFinish Hand Finishing | Wing Walk as per dwg QSI005 4.4 Batch 121505 Memo | 0.00 0.00 | | | | 4 | ✓ | | 12-5-11 |

M 12/11/34

| W/O: | | WORK ORDER CHANGES | | | | | |
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Setup Start *NS1*

Stop *NS2*

Cust Item ID:

Start Date: 24/04/2012 **Start Qty:** 4.00

4

Customer:

Required Date: 08/05/2012 **Req'd Qty:** 4.00

4

Reference:

Run Start *NR1*

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Stop *NR2*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|

220 QC3- Inspect Part Finish

0.00

220

QC Memo

0.00

Quality Control

| | | |
|-----|---------------------------------------|------|
| 230 | Identify as per dwg & Stock Location: | 0.00 |
|-----|---------------------------------------|------|

0.00

230

| Packaging | Memo |
|-----------|------|
|-----------|------|

0.00

Packaging

| | | |
|-----|---|------|
| 240 | QC21- Final Inspection - Work Order Release | 0.00 |
|-----|---|------|

0.00

240

QC Memo

0.00

Quality Control

MCJ 12/06/13

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
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NOTE: Date & initial all entries

Picklist Print

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Page 1

Work Order ID: 83742

83742

Parent Item: D3562-042

D3562-042

Parent Item Name: Step Assembly, RH

Start Date: 24/04/2012

Required Date: 08/05/2012

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev:A New Issue 06-11-09 JLM
 IPP rev B ECN 987 07.10.09 EC verified by: DD
 IPP Rev:C ECN1048 07-12-18 DD verified by: EC
 IPP Rev:D 08-07-28 add chemical conversion coat DD verified by:EC

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Qty per Kit | Total Qty | Qty Issued | Date Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|

D2622-120C

Manufactured

No

100

Each

129.7300

1

4

D2622-120C

Step Extrusion

**

Ac 12.05.01

Location

Loc Qty

Loc Code

HALL

16.37

46910

2

64409

6

66970

7.7

68293

0.25

72131

0.42

WA

104

81507

104

WA013

9.36

75781

2

77612

7.36

D2734

Manufactured

No

140

Each

53.0000

2

8

D2734

Step End Plate

**

Ac 12.05.09

Location

Loc Qty

Loc Code

WA

53

76985

25

80682

28

D3560-042

Manufactured

No

140

Each

0.0000

1

4

D3560-042

Arm Weldment

**

B80260 (2) Ac 12.05.02
 B81124 (2)

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
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NOTE: Date & initial all entries

Picklist Print

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Page 2

Work Order ID: 83742

Parent Item: D3562-042

Parent Item Name: Step Assembly, RH

83742

D3562-042

Start Date: 24/04/2012

Required Date: 08/05/2012

Start Qty: 4.00

Required Qty: 4.00

D3560-044

Manufactured No

140

Each

4.0000

1

4

D3560-044

Arm Weldment

**

Ar 12.05.02

Location

Loc Qty

Loc Code

WA

3

79088

1

81126

2

WA013

1

71950

1

MS20600-AD4W5

Purchased

No

160

Each

475.0000

32

128

MS20600-AD4W5

Blind Rivet

**

Ar 12.05.07

Location

Loc Qty

Loc Code

ST321

475

121255

275

121349

200

128

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Shop Packet Print

Page 2

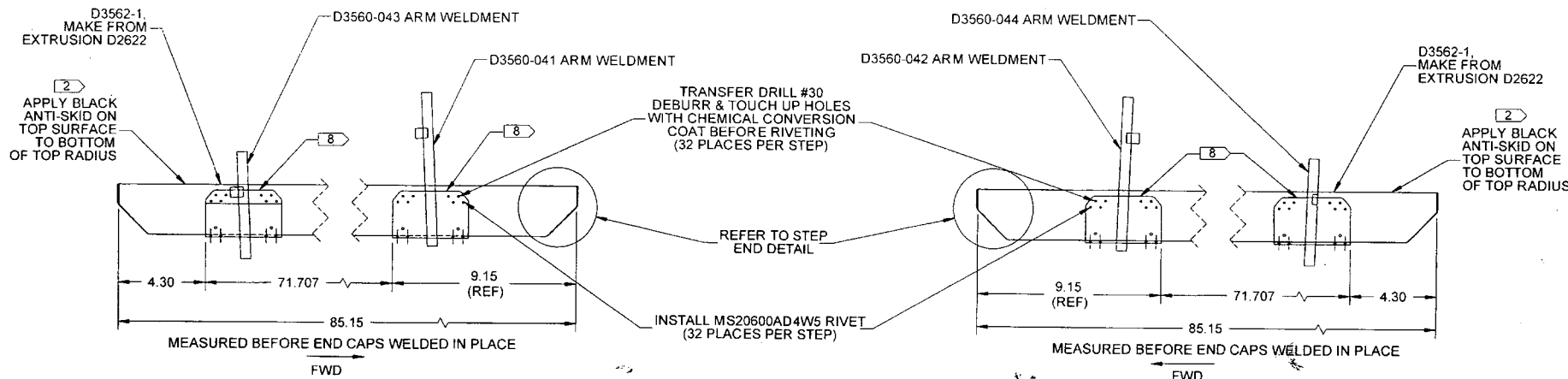
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NOTE: Date & initial all entries



D3562-041 LH STEP ASSEMBLY

D3562-042 RH STEP ASSEMBLY

NOTES:

1) MATERIAL: N/A

2) FINISH:

i) CHEMICAL CONVERSION COAT STEP EXTRUSION

PER DART QSI 005 4.1 BEFORE ASSEMBLY

ii) POWDER COAT ASSEMBLY GLOSS WHITE (4.3.5.1) OR
GREY SANDEX (4.3.5.6) OR
BLACK SANDEX (4.3.5.7) OR
GREEN SANDEX (4.3.5.8) PER DART QSI 005 4.3

iii) BLACK ANTI-SKID PAINT PER DART QSI 005 4.4

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX

6) IDENTIFICATION: NONE

7) WEIGHT: 8.79 lbs

8) INSTALL ARM WELDMENTS WITH A LAYER OF MAGNOBOND 6398 BETWEEN THE ARM WELDMENT AND STEP EXTRUSION. FILL ANY TOOLING HOLES WITH MAGNOBOND 6398. CLEAN OFF EXCESS BEFORE POWDER COATING.

9) WELDING: PER DART QSI 004

NOTE: ALL WELDS SHALL BE 100% VISUALLY INSPECTED BY A QUALIFIED INSPECTOR PER DART QSI 004

ROUND CORNER OF EXTRUSION TO MATCH BEND RADIUS OF END PLATE

D2734 END PLATE
(TYP 2 PLACES)
SCALE 1:2

| QTY -041 | QTY -042 | P/N | DESCRIPTION |
|----------|----------|--------------|------------------|
| X | | D3562-041 | LH STEP ASSEMBLY |
| | X | D3562-042 | RH STEP ASSEMBLY |
| 1 | | D3560-041 | ARM WELDMENT |
| | 1 | D3560-042 | ARM WELDMENT |
| 1 | | D3560-043 | ARM WELDMENT |
| | 1 | D3560-044 | ARM WELDMENT |
| 32 | 32 | MS20600AD4W5 | RIVET |
| 2 | 2 | D2734 | END PLATE |

| | | | |
|------------|---|----|----------|
| E | ADD QTY (2) TO D2734 END PLATE ON D3562-042 | PH | 08.01.11 |
| D | REMOVE D2808 SPACER NOTE; REDRAWN IN SOLIDWORKS | DC | 07.11.16 |
| C | NOW MAGNOBOND, ADD D2808, REMOVE 4 RIVETS | CP | 07.06.19 |
| B | ARMS NOW RIVETED TO STEP | CP | 07.01.15 |
| A | NEW ISSUE | CP | 06.09.26 |
| REV. | DESCRIPTION | BY | DATE |
| DESIGN | | | |
| DRAWN | | | |
| CHECKED | | | |
| MFG. APPR. | | | |
| APPROVED | | | |
| DE APPR. | | | |
| DATE | 08.01.11 | | |

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO.

D3562

TITLE
STEP ASSEMBLY

REV. E

SHEET 1 OF 1

SCALE

1:5

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SHOP COPY
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ENGINEERING
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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

NO. 83742 MLC
12/04/24

| W/O: | | WORK ORDER CHANGES | | | | | |
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